

Work Order ID 84606

May-17-12 10:17:10 AM

\*84606\*

Page 1

Item ID: D3197-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bar Assembly

Start Date: 17/05/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/12 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3197	Rev B								
100	BAND SAW	0.00							
*100*									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 29.125" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
*110*									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	1-Face ends to length per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

Ship May 28 ~~SHIP~~

FK 12/05/22

FK 12/05/22

FK 12/05/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*84606\***

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Item ID: D3197-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bar Assembly

Start Date: 17/05/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

Lathe Conv

CONVENTIONAL LATHE

0.00

~~10~~ 12-5-22

6

Memo

0.00

Conventional Lathe

Chamfer as per Dwg D3197

140

**\*140\***

QC

QC8- Inspect parts - second check

0.00

JL 12-05-22

6

Memo

0.00

Quality Control

150

**\*150\***

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

6 12-5-23

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 84606

\*84606\*

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May-17-12 10:17:10 AM

Item ID: D3197-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bar Assembly  
 Start Date: 17/05/2012 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 25/05/2012 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				6X	0	12/05/23	M.F.
	Memo START TIME: 3:50 FINISH TIME: 3:20 P	0.00							
		OVEN TEMPERATURE: 4720							
170 *170* QC	QC3- Inspect Part Finish	0.00				6x	0	12/05/23	M
Quality Control	Memo	0.00							
180 *180* Small Fab	Small Fab.	0.00				6x			12/05/30
Small Fab	Memo Assemble D3197-041 as per Dwg D3197	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84606

May-17-12 10:17:10 AM

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Item ID: D3197-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bar Assembly  
 Start Date: 17/05/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 25/05/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				(6)			SD 12/05/30
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>260</u>  Memo	0.00  0.00				(6)			12/05/30
210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							MW 12/05/30 ME 12-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



May-17-12 10:17:14 AM

**\*84606\***

**\*D3197-041\***

**Required Date:** 25/05/2012

**Required Qty: 6.00**

**Comments:** IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev:B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24		Purchased	No			100	Each	46.0000	2	12			
*MS27039-1-24*													
Screw									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST292				46					
					100151			46					
AN960JD10	NAS1149D0363J	Purchased	No			180	Each	0.0000	6	36			
*AN960JD10*													
Washer									**				
D2690-5		Manufactured	No			180	Each	5.0000	2	12			
*D2690-5*													
Lanyard Assembly									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST013				5					
					81540			5					
D3242-1		Manufactured	No			180	Each	20.0000	2	12			
*D3242-1*													
Tag									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				20					
					79825			4					
					81883			16					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 84606

\*84606\*

Parent Item: D3197-041

\*D3197-041\*

Parent Item Name: Bar Assembly

Start Date: 17/05/2012

Required Date: 25/05/2012

Start Qty: 6.00

Required Qty: 6.00



D3489-3-200

Manufactured No

180

Each

10.0000

2

12

\*D3489-3-200\*

PIP PIN

\*\*

*EP 12/05/30*

Location

Loc Qty

Loc Code

GA

10

75792

3

81884

7

3

M7075T73R1.000

Purchased

No

180

f

53.3750

2.42

18.15

\*M7075T73R1 000\*

7075-T73 Rd Bar 1.00

\*\*

*B84853 (9x)*

Location

Loc Qty

Loc Code

MAT012

53.375

120503

21.375

120568

32

18.15

MS21042L3

Purchased

No

180

Each

2,556.000

2

12

\*MS21042L3\*

Nut

\*\*

*FK 12/05/22*

Location

Loc Qty

Loc Code

ST300

2556

117885

32

119017

1094

119075

138

121349

359

121444

933

12

*EP 12/05/30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	84606
Description: Bar		Part Number:	D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.000	✓		FK-03	Tape
25.06	+/-0.030	25.06	✓		"	"
11.44	+/-0.030	11.44	✓		"	"
0.500	+/-0.010	.500	✓		FK-04	Vern
0.250	+/-0.030	.251	✓		"	"
Ø0.219	+0.005/-0.000	.221	✓		"	"
Ø0.191	+0.005/-0.000	.192	✓		"	"
1.000	+/-0.005	1.000	✓		"	"
2.69	+/-0.030	2.685	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
0.300	+/-0.010	.300	✓		"	"
0.063 x 45°	+/-0.010	.063 x 45°	✓		RA26	Vern
Ø1.000	+/-0.010	.998	✓		FK-04	Vern

Measured by: F.K. [Signature]	Audited by: J.L. [Signature]	Prototype Approval:	N/A
Date: 12/05/22	Date: 12-05-22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

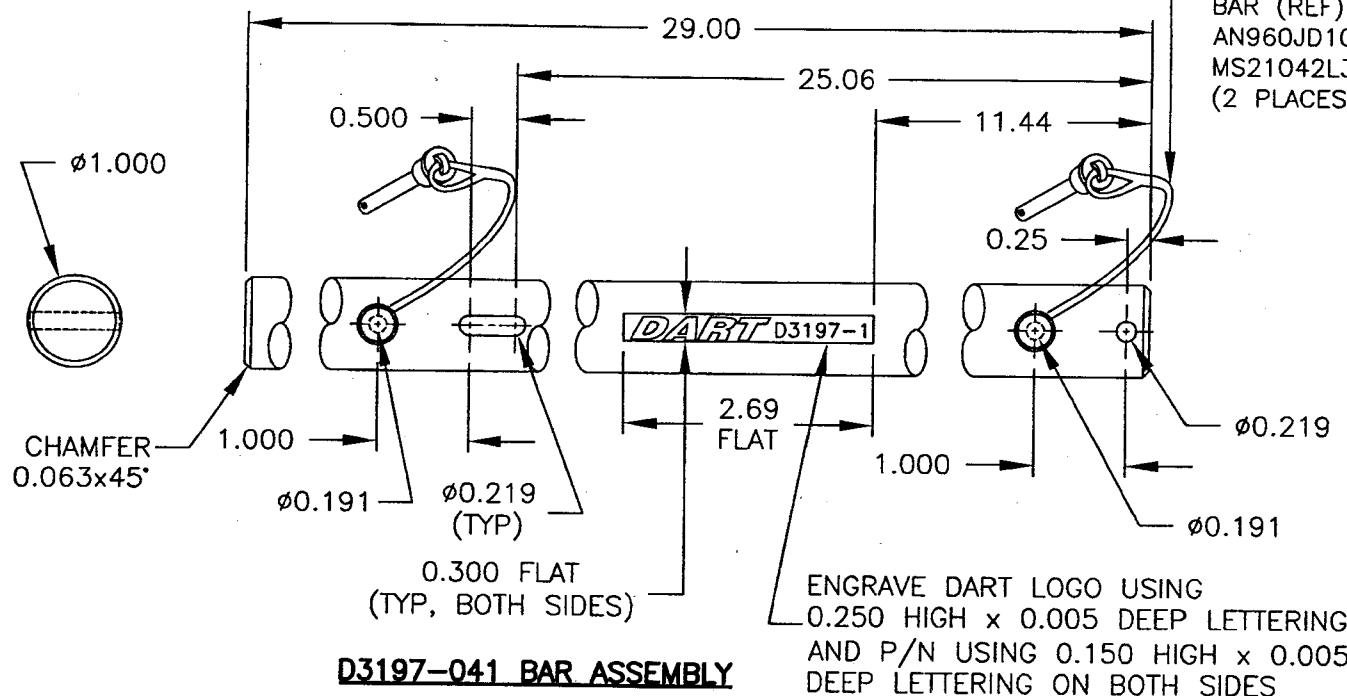
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED

**DART**

D3489-3-200 PIP PIN (1)  
D3242-1 TAG (1)  
MS27039-1-24 BOLT (1)  
AN960JD10 WASHER (1)  
D2690-5 LANYARD (1)  
AN960JD10 WASHER (1)  
BAR (REF)  
AN960JD10 WASHER (1)  
MS21042L3 NUT (1)  
(2 PLACES)



### D3197-041 BAR ASSEMBLY

### D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi$ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84606  
12/25/17

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	D3197	SHEET 1 OF 1
		BAR		SCALE 1:1
A	03.07.01	NEW ISSUE		
B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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